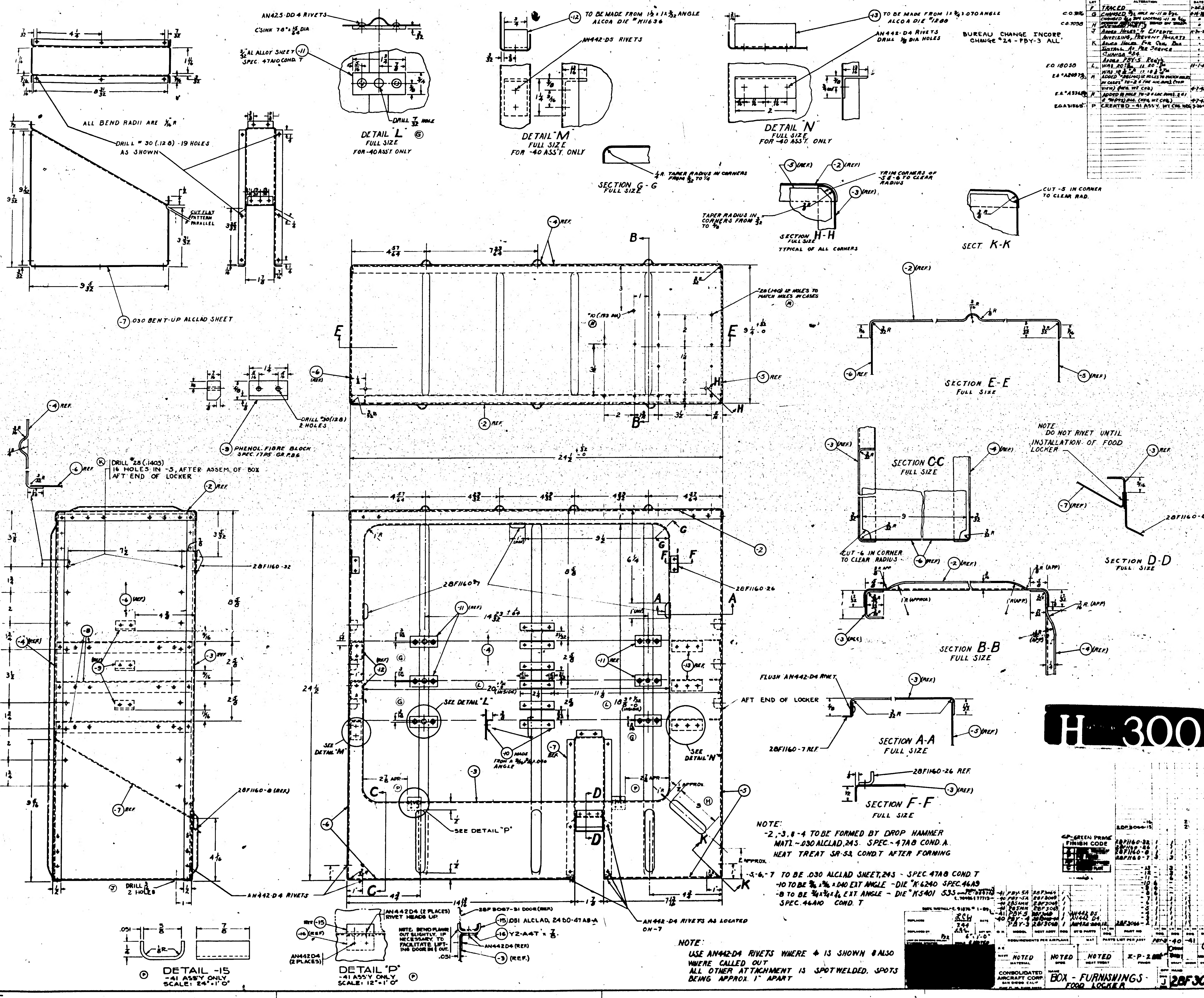

AN425-DD4 RIVETS
C'SINK 78° x 15/64 DIA
3/32 AL ALLOY SHEET -11 SPEC. 47A0 COND. T
DRILL 7/32 HOLE
DETAIL "L" G
FULL SIZE
FOR -40 ASS'Y ONLY
-12 TO BE MADE FROM 1 1/2 x 1 1/2 x 3/32 ANGLE ALCOA DIE #K11636
AN442-D5 RIVETS
DETAIL "M"
FULL SIZE
FOR -40 ASS'Y. ONLY
-13 TO BE MADE FROM 1 x 3/4 x .070 ANGLE ALCOA DIE #1288
AN442-D4 RIVETS DRILL 1/8 DIA HOLES
DETAIL "N"
FULL SIZE
FOR -40 ASS'Y. ONLY
BUREAU CHANGE INCORP. CHANGE #24 - PBY-3 ALL
SUPPLIES & EQUIPMENT CLASSIFICATION
LET | ALTERATION | DATE | BY
F TRACED
C.O.7016 G CHANGED HOLE IN -11 TO 5/32
CHANGED DIM LOCATING -11
C.O.7038 H
J ADDED HOLES TO EXPEDITE ANODIZING, PREVENT POCKETS
K ADDED HOLES FOR CELL BOX INSTALL. AS PER SERVICE CHANGE #24
ADDED PBY-5 REQ'TS.
E.O.18030 L WAS 20 IS 20 / WAS 18 IS 18
E.A.#A20073 M ADDED #28(.140) 12 HOLES TO MATCH HOLES IN CASES TO -2 & THE LOC. DIMS. (TOP VIEW) (NEG. WT CHG.) 4-7-42
E.A.#A336 N ADDED HOLE TO -2 & LOC. DIMS. & (.093) DIA. (NEG. WT CHG.) 4-7-42
E.O.A31565 P CREATED -41 ASS'Y. WT CHG. NEG.
ALL BEND RADII ARE 1/16 R
DRILL #30 (.128) - 19 HOLES AS SHOWN
CUT FLAT PATTERN PARALLEL
-7 .030 BENT-UP ALCLAD SHEET
SECTION G-G FULL SIZE
1/4 R. TAPER RADIUS IN CORNERS FROM 3/32 TO 1/4
TRIM CORNERS OF -2 & -3 TO CLEAR RADIUS
TAPER RADIUS IN CORNERS FROM 3/32 TO 1/4
SECTION H-H FULL SIZE
TYPICAL OF ALL CORNERS
CUT -5 IN CORNER TO CLEAR RAD.
SECT. K-K
#28 (.140) 12 HOLES TO MATCH HOLES IN CASES M
#10 (.193 DIA)
SECTION E-E FULL SIZE
-9 PHENOL FIBRE BLOCK SPEC. 17P5 GR. P.B.6
DRILL #30 (.128) 2 HOLES
DRILL #28 (.1405) 16 HOLES IN -5, AFTER ASSEM. OF BOX
AFT END OF LOCKER
NOTE: DO NOT RIVET UNTIL INSTALLATION OF FOOD LOCKER
SECTION C-C FULL SIZE
CUT -6 IN CORNER TO CLEAR RADIUS
SECTION D-D FULL SIZE
28F1160-8
28F1160-32
28F1160-7
28F1160-26
SEE DETAIL "L"
SEE DETAIL "M"
SEE DETAIL "N"
SEE DETAIL "P"
-10 MADE FROM A 3/4 x 3/4 x .040 ANGLE
SECTION B-B FULL SIZE
FLUSH AN442-D4 RIVET
AFT END OF LOCKER
SECTION A-A FULL SIZE
28F1160-7 REF.
SECTION F-F FULL SIZE
28F1160-26 REF.
H 300
NOTE:
-2, -3, & -4 TO BE FORMED BY DROP HAMMER
MAT'L - .030 ALCLAD, 24S. SPEC. - 47A8 COND. A.
HEAT TREAT SR-53, COND T AFTER FORMING
-5, -6, -7 TO BE .030 ALCLAD SHEET, 24S - SPEC. 47A8 COND. T
-10 TO BE 3/4 x 3/4 x .040 EXT ANGLE - DIE #K-6240 SPEC. 46A9
-8 TO BE 3/4 x 3/4 x 1/16 EXT ANGLE - DIE #K5401 53S SPEC. 46A10 COND. T
DRILL 3/8 2 HOLES
AN442-D4 RIVETS
AN442-D4 RIVETS AS LOCATED ON -7
28F1160-8 (REF.)
DETAIL -15
-41 ASS'Y ONLY
SCALE: 24" = 1'-0"
AN442D4 (2 PLACES) RIVET HEADS UP.
NOTE: BEND FLANGE OUT SLIGHTLY, IF NECESSARY, TO FACILITATE LIFTING DOOR IN CUT.
28F3067-51 DOOR (REF.)
-15 .051 ALCLAD, 24SO-47A8-A
-16 Y2-A4T x 7/8
AN442D4 (REF)
DETAIL "P"
-41 ASS'Y ONLY
SCALE: 12" = 1'-0"
NOTE:
USE AN442-D4 RIVETS WHERE + IS SHOWN & ALSO WHERE CALLED OUT
ALL OTHER ATTACHMENT IS SPOTWELDED, SPOTS BEING APPROX. 1" APART
GP-GREEN PRIME
FINISH CODE
28F3066-15
28F1160-32
28F1160-26
28F1160-8
28F1160-7
-41 PBY-5A 28F3069
-40 PBY-5A 28F3069
-40 28-5AMN 28F3069
-40 28-5MN 28F3069
-41 PBY-5
-40 PBY-4
PBY-3 28F3069
AN442-D5
AN442-D4
28F3066
REPLACES
REPLACED BY
DATE
6" = 1'-0"
REQUIREMENTS PER AIRPLANE
PARTS LIST PER ASSY
-40 -41
[redacted]
NAVY NOTED MATERIAL
NOTED SPEC
NOTED HEAT TREAT
Z-P-2 FINISH
CONSOLIDATED AIRCRAFT CORP. SAN DIEGO CALIF.
BOX - FURNISHINGS - FOOD LOCKER
J 28F3066